



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3564-9

Job Sheet 184837



Part No: D3564-9

Job Qty: 10 ea

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	10 pcs	11/2/18	11/2/18	0.00	1.93	Waterjet 1		OK 18/10/18 DAS 68
120	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC8		OCT 30 2018 68
130	Brake NC	10 pcs	11/2/18	11/2/18	0.22	0.53	Brake NC 1		DAS 9-89
140	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC5		SK 38 9-89
150	Autoweld 1	10 pcs	11/2/18	11/2/18	0.00	4.00	Automated welding		JML 9-89
160	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC10		2
170	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC5		2
180	SprayPaint	10 pcs	11/2/18	11/2/18	0.00	1.75	Spray Paint		18-12-08 DAS
190	QC	10 pcs	11/2/18	11/2/18	0.00	0.00	QC5		DEC 10 2018 68
200	Packaging	10 pcs	11/2/18	11/2/18	0.00	0.00	Packaging3-1	FP-002	18-12-08 68
210	QC21-SA	10 Ea	11/2/18	11/2/18	0.00	0.00	QC21		DEC 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	14.1000 sf (1.41 ea)	100-Waterjet	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S16GA	14	254	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches ± 0.010	3.237 3.217		
2	Wearshoe	2.432inches ± 0.010	2.442 2.422		
3	Wearshoe	2.500inches ± 0.030	2.530 2.470		
4	Wearshoe	6.000inches ± 0.010	6.010 5.990		
5	Wearshoe	12.104inches ± 0.010	12.114		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
--------	---------	-----------------	-----------------------

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

			12.094
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990
7	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990
8	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970
9	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970
10	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290
12	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290
13	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187
14	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365
15	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053

Plex 10/17/18 10:59 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S120439



Part: D3564-9

Job No: 184837

Serial No/Batch: S120439

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/22/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							